

# Work Order ID 94410

Monday, December 17, 2012 1:40:44 PM

\*94410\*

ASAP

Page 1

Item ID: D3137-5 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Washer  
 Start Date: 12/17/2012 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 12/17/2012 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: MUP Date: 12-12-17 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3137	Rev F

100	Hardinge CNC LATHE SMALL	0.00							
*100*									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	1-Machine as per Folio FA471 and Dwg D3137 2-Identify as D3137-5 3-Deburr								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

DAS  
04  
2-89

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Item ID: D3137-5 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Washer  
Start Date: 12/17/2012 Start Qty: 12.00 \*12\* Cust Item ID:  
Required Date: 12/17/2012 Req'd Qty: 12.00 \*12\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				12 X	0		mt 12/12/17
140 *140* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				12	0	12/12-17	QC3
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <i>SA</i>  Memo	0.00  0.00				12	0		SP 12/12/17

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Item ID: D3137-5

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Washer

Stop **\*NS2\***

Start Date: 12/17/2012 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 12/17/2012 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/12/18 *[Signature]**MF*

12-12-18

# Picklist Print

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Page 1

Work Order ID: 94410

Parent Item: D3137-5

Parent Item Name: Washer

Start Date: 12/17/2012

Required Date: 12/17/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A04.11.04New issueKJ/JLM  
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 6061-T6 Round Bar .750"		Purchased	No			100	f	70.5180	0.0208	0.2627368	0.379	12/12/17	

Location

Loc Qty

Loc Code

MAT012

13

120734

13

MAT013

57.518

121282

9.024

122081

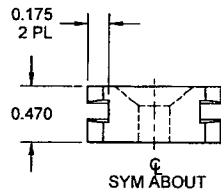
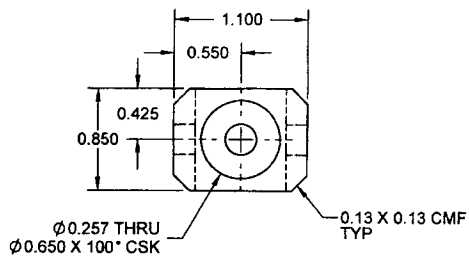
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→ 123757

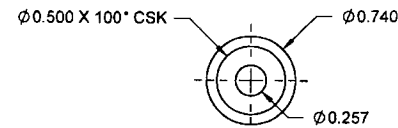
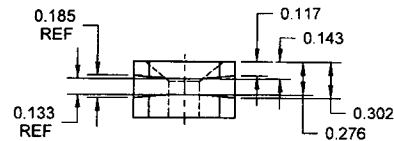
22

0.379

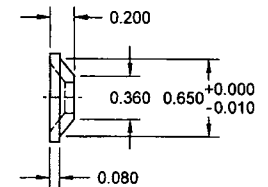
NOT  
Pulled



**D3137-3 GUIDE**



**D3137-5 WASHER**



**NOTES:**

- 1) MATERIAL: -3  
DELTRIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELTRIN-B)  
-5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

**RELEASED**

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JJS		
CHECKED	JJS	DRAWING NO.	REV. F
MFG. APPR.	JJS	D3137	SHEET 5 OF 5
APPROVED	JJS	TITLE	SCALE
DE APPR.	JJS	BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



